

143588

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/15/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 4/26/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: Process Plan: SA Date: 20160316 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
IIN D412-761	E	MCS 16-04- MCS

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-047	CHG002

MLJ 16-04-21

2 DAS
28
9.82 APR 29 2016

110	Pick Kit	0.00
-----	----------	------

110		
Packaging	Memo	0.00

Packaging

2 MC ¹⁷ **DAS** 27 16-04-2e
9-89

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120		
QC	Memo	0.00

Quality Control

2
DAS
28
9-89
APR 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 143588

143588

Page 2

Item ID: D412-761-047

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Instrument Panel

Stop ***NS2***

Start Date: 4/15/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00				DAS 28 9-89	BAS 27 9-89	APR 29 2016	
Packaging	Identify and pack for shipping as per PPP D412-761-047 Location: PPP Rev: <u>143588</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

ML5

MAY 02 2016

MF
16-4-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

March 16, 2016 1:51:54 PM

Page 1

Work Order ID: 143588

143588

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B
13.01.15 as per ECN13-511 DD Verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-4A		Purchased	No			110	Each	417.0000	4	8			
AN3-4A									**				
Bolt													

DAS
28
9-89

Location	Loc Qty	Loc Code
over003	300	
m134502	300	
ST350	117	
m133990	117	

D3705-11		Manufactured	No			110	Each	6.0000	1	2			
D3705-11									**				
Main Panel													

DAS
28
9-89

Location	Loc Qty	Loc Code
ST052	6	
139238	6	

D3705-7		Manufactured	No			110	Each	5.0000	1	2			
D3705-7									**				
Main Panel													

DAS
28
9-89

Location	Loc Qty	Loc Code
ST052	5	
105314	5	

D3705-9		Manufactured	No			110	Each	6.0000	1	2			
D3705-9									**				
Panel													

DAS
28
9-89

Location	Loc Qty	Loc Code
ST052	6	
139239	6	

Picklist Print

March 16, 2016 1:51:54 PM

Page 2

Work Order ID: 143588

143588

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

D4758-1 Manufactured No

110 Each 8.0000 2 4

D4758-1

Blanking Plate

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST123

8

105692

4

139241

4

4

D4758-3 Manufactured No

110 Each 12.0000 3 6

D4758-3

Blanking Plate

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST123

12

139240

12

6

NAS1149D0332J Purchased No

110 Each 1,923.000 10 20

NAS1149D0332.J

Washer

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

54

m133498

54

GA

118

m132677

118

ST260a

600

m133988

600

20

ST264

1000

m134502

1000

ST266

137

m133498

137

March 16, 2016 1:51:54 PM

Shop Packet Print

Page 2

Picklist Print

Page 3

March 16, 2016 1:51:54 PM

Work Order ID: 143588

143588

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

D3705-041

Manufactured No

110

Each

0.0000

1

2

**

D3705-041

Instrument Paney Assy

DAS
28
9-89

~~14544~~ 14544

DAS
27
9-89

D3707-1

Manufactured No

110

Each

16.0000

2

4

**

D3707-1

Mounting Lug

DAS
28
9-89

MLJ 16-04-20

DAS
27
9-89

Location

Loc Qty

Loc Code

ST052

16

134309

16

4

D3790-1

Manufactured No

110

Each

1.0000

1

2

**

D3790-1

Indexing Block

DAS
28
9-89

B143646 X1

DAS
27
9-89

MLJ 16-04-20

Location

Loc Qty

Loc Code

ST054

1

105301

1

1

D3867-1

Manufactured No

110

Each

0.0000

1

2

**

D3867-1

Connector Plate

DAS
28
9-89

B134056 X2

DAS DAS
27 27
9-89 9-89

MLJ

AN526C1032R6

Purchased No

110

Each

380.0000

6

12

**

AN526C1032R6

Screw

DAS
28
9-89

MLJ 16-04-20

Location

Loc Qty

Loc Code

ST327

380

1892

380

12

DAS
27
9-89

March 16, 2016 1:51:54 PM

Shop Packet Print

Page 3

Picklist Print

March 16, 2016 1:51:54 PM

Page 5

Work Order ID: 143588

143588

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-27

Purchased

No

110

Each

40.0000

1

2

MS27039-1-27

Screw

MCS 16-04-2027
9-89

DAG
28
9-89

Location

Loc Qty

Loc Code

ST279

40

110606

40

2

MS21042L3

Purchased

No

110

Each

2,700.000

4

8

MS21042L3

Nut

MCS 16-04-2027
9-89

DAG
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

861

m133790

61

m134360

800

OVER007

1200

m134360

1200

8

ST304

539

m134039

539

MS21919-WDG8

Purchased

No

110

Each

76.0000

2

4

MS21919-WDG8

Clamp

MCS 16-04-2027
9-89

DAG
28
9-89

Location

Loc Qty

Loc Code

ST293

76

m128057

76

4

DART AEROSPACE LTD.
IIN-D412-761

Page 11 of 13

DAS

28

9-89

(CONTINUED FROM PAGE 10)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
				1				D3705-041	INSTRUMENT PANEL ASSEMBLY
				1				D3705-043	* INSTRUMENT PANEL WELDMENT
				1				D3335-1	* SPRING
				1				D3705-5	* ACCESS PANEL
				1				D3706-041	* LOCK BRACKET ASSEMBLY
				1				D3706-5	* PIN
				2				D3707-3	* MOUNTING LUG
				2				AN3-3A	* BOLT
				4				AN526C1032R6	* SCREW
				1				MS171498	* SPRING SLOTTED PIN
				4				MS24693-C272	* SCREW (OR MS24693-S272)
				2				NAS1149D0332J	* WASHER (OR AN960JD10L)
				1				NAS1149D0563J	* WASHER (OR AN960JD516)
				1				D3705-7	FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-9	FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-11	FACE PLATE (FOR 212, 214, 412, MODELS)
				2				D3707-1	MOUNTING LUG
				1				D3790-1	INDEXING BLOCK
				1				D3867-1	CONNECTOR PLATE
				2				D4758-1	BLANKING PLATE
				3				D4758-3	BLANKING PLATE
				4				AN3-4A	BOLT
				6				AN526C1032R6	SCREW
				2				AN743-12	BRACKET
				6				AN960JD10L	WASHER
				6				MS21075L3	NUTPLATE (OR MS21073-3)
				4				MS24693-C272	SCREW (OR MS24693-S272)
				1				MS27039-1-17	SCREW
				1				MS27039-1-27	SCREW
				4				MS21042L3	NUT
				2				MS21919WDG8	CLAMP
				4				NAS1149D0332J	WASHER (OR AN960JD10L)
					1	1		D3694-041	MOUNTING PLATE ASSEMBLY
					1	1		D3694-1	* KEYWAY
					1	1		D3694-3	* PROTECTIVE PLATE
					1	1		D3694-5	* MOUNTING PLATE
					1	1		AN526C1032R8	* SCREW
					4	4		MS21042L3	* NUT
					2	2		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					1	1		MS24693-C271	* SCREW (OR MS24693-S271)
					4	4		MS24693-C273	* SCREW (OR MS24693-S273)
					5	5		NAS1149D0363J	* WASHER (OR AN960JD10)
						1	1	D3695-041	SLIDER ASSEMBLY
						1	1	D3695-1	* SLIDER
						1	1	D3695-3	* STOPPER
						1	1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
						4	4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
						4	4	MS24693-C276	* SCREW (OR MS24693-S276)
						1	1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 12)

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **E**
 Date: 12.12.07

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
								D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
								D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X								D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X							D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1					D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X					D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X				D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X			D412-761-049	ARMREST KIT, LH
	1					X		D412-761-051	ARMREST KIT, LH
							X	D412-761-141	VENT KIT
		1						D3589-041	LATCH ASSEMBLY
		1						D3589-047	FORWARD GUIDE
		1						D3589-049	AFT GUIDE
		2						MS16997-24	SCREW
		2						MS21042L06	NUT
		2						NAS1149DN632J	WASHER (OR AN960JD6L)
			1					D3676-1	LARGE BUBBLE WINDOW
			1					D3678-1	PLACARD
			1					D3678-3	PLACARD
			1					D3700-1	INBOARD WINDOW DOUBLER
			1					D3700-3	OUTBOARD WINDOW DOUBLER
			1					D3701-1	FLOOR DOUBLER
			1					D3702-1	FORWARD DOUBLER
			1					D3703-1	AFT DOUBLER
			1					D3703-3	AFT CORNER DOUBLER
			1					D3703-5	AFT CAP
			1					D3704-1	ESCUTCHEON
			1					D3704-3	ESCUTCHEON
			1					D3708-1	ANGLE
			1					D3708-3	ANGLE
			1					D3709-1	ANGLE
			1					D3709-3	ANGLE
			1					D3802-1-135	SEAL
			1					DT9458	CUTTING TEMPLATE
			26					AN3-7A	BOLT
			26					MS21042L3	NUT
			1					MS24694-C5	SCREW (OR MS24694-S5)
			1					MS24694-C13	SCREW (OR MS24694-S13)
			1					NAS43DD3-24	SPACER
			52					NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 11)

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
X										D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X								D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X							D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1					D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		1					D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X				D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1					X			D412-761-049	ARMREST KIT, LH
			1					X		D412-761-051	ARMREST KIT, LH
1	1								X	D412-761-141	VENT KIT
1	1									204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153	BELL 204, 205, 210, 412 OEM DOOR